

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018086**Date Inspected:** 13-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Li Yang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Trial assembly yard, 11DE-11EE, SP-C5.

SMAW welding of weld joint OBE11C-009; located at Trial assembly yard. Welder is identified as 067752; ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

Trial assembly yard, 11DE-11EE, BP-D6.

SMAW welding of weld joint OBE11C-008; located at Trial assembly yard. Welders are identified as 040320, 053871; ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

Trial assembly yard, 11DE-11EE, DP-EP-E2.

SMAW welding of weld joint CA090-002, CA094-006; located at Trial assembly yard. Welder is identified as 044515; ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4B-FCM-1.

Trial assembly yard, 11DE-11EE, EP-SP-E6.

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SMAW welding of weld joint SEG072-046, CA093-001; located at Trial assembly yard. Welder is identified as 040367; ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4B-F.

Trial assembly yard, 11CW-11DW, EP-B3.

During Random Visual in process Inspection, this QA inspector observed repair excavation done on Transverse splice of Edge panels at intersection of OBG segment 11CW-11DW. The weld is identified as OBE11A-001 (EP-B3). This excavation was done according to AB/F-“D” scan Ultrasonic Inspection Report “UT-11W-057”. This QA inspector measured size of excavation. Excavation was 150mm in length, 55mm wide & 15mm deep. Excavation is located at 430mm from W1 side (SP-EP Weld) of the weld. ZPMC have prepared Weld repair report for this repair WRR # B-WR16824. The attached photographs provide additional detail.

This QA Inspector carried out NDE on following
Trial assembly yard, 11BW-11CW.

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: 11122010-1) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as weld between Bottom panel to Side Panel at the transverse Splice of OBG Segment 11BW- 11CW, Cross beam Side. The weld designations were as;

SEG067A-045. (11BW-11CW, BP-SP-W4), only @ Y-location 850.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Juvekar,Amit	Quality Assurance Inspector
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Reviewed By:	Dsouza,Christopher	QA Reviewer
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